

md



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D407-667-205
Job Sheet 181962



Part No: D407-667-205 **Job Qty:** 1 ea

Part Name: Aft Crosstube - High 407



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/14/18

Job Tracking No:

Due Date: 8/31/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV G IPP Rev:C 05.09.02 Add holes for comp. w/ Bell Skids KJ/JLM IPP Rev:D Add Magnobond,Rubber Cushion,Clamps 07-02-19 JLM IPP Rev:E 08-05-22 add comment seq. 6 & QC15 & QC5 DD verf:EC IPP Rev:F 08-06-12 add comment seq. 24 DD verf:EC IPP Rev:G 08-08-19 revE per dwg DD verf:EC IPP Rev H 09.01.06 ECN 08-562 EC verf:DD IPP Rev:I 10.04.07 revise route seq. in born DD verf:JLM IPP Rev J 11.04.26 removed abrasion strip ecn 11-551 EC verf:DD IPP REV:K 11.10.03 DEOD407-667-245-F-2 DD verf:EC

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S103187



Part: D407-667-205

Job No: 181962

Serial No/Batch: S103187

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH01-5 Issue 3, FAA STC SRD1304NY 05/12/15, JCAB JAI

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Stores/Pkg-1		GP 2018-08-10
110	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging1-4		GP 2018-08-10
120	CNC Bend Skidtube	1 pcs	8/31/18	8/31/18	1.99	3.33	CNC Bend Skidtube		GP 2018-08-10
130	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC15		GP 2018-08-10
140	Crosstubes	1 pcs	8/31/18	8/31/18	0.00	3.47	Crosstubes-2		GP 2018-08-10
150	HandFXtube	1 pcs	8/31/18	8/31/18	0.00	0.91	HandFinish5		GP 2018-08-10
160	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC7-3		GP 2018-08-10
170	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC5		GP 2018-08-10
180	Outsource	1 pcs	8/31/18	8/31/18			SKY002-VC	2	GP 2018-08-10
190	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging2		GP 2018-08-10
200	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC6		GP 2018-08-10
210	SprayPaint	1 pcs	8/31/18	8/31/18	0.00	1.39	Spray Paint		GP 2018-08-10
220	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC14		GP 2018-08-10
230	Crosstubes	1 pcs	8/31/18	8/31/18	0.00	3.47	Crosstubes-2		GP 2018-08-10
240	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC5		GP 2018-08-10
250	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging1-4		GP 2018-08-10
260	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC4		GP 2018-08-10
265	DC	1 pcs	8/31/18	8/31/18	0.00	0.00	DC		GP 2018-08-10
270	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2		GP 2018-08-10
280	QC21-FG	1 Ea	8/31/18	8/31/18	0.00	0.00	QC21		GP 2018-08-10

Part Op 120 - 1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio 21

Descriptions: 140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D407-667-245. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes. Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245 5-Drill aft rivet holes using drill Jig DT8787 aft as per Dwg D407-667-245. Drill only the top (2) holes. 6- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint. 8-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***Deburr & inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

150 - ***IMMEDIATELY AFTER GRINDING***

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 0380

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside and outside crosstube as per DEO D407-667-245 and QSI 005 4.2 ***Mask underside of crosstube as shown*** 3- Apply clear coat as per dwg Clear Coat Batch: 138832 Prime 138877

220 - Then, Wrap in plastic bag to protect from scratches

230 - 1- Install chaffing shield as per D407-667-245 using DT10096 to establish 8.90 dimension. Top holes should be facing up. ****Ensure chaffing is to be position "overlap" AFT**** A/R Proseal 890 Batch: 506374 EXP: 3/19 2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe 3-Install support with Scotch-Weld DP460 and install clamps as per Dwg D407-667-245 using installation jig DT9025. Torque clamps as per dwg A/R Scotch-Weld DP460 Batch: 5064031 EXP: 4/19 ***LET CURE FOR 24 HOURS*** CURE TIME: START: 18-10-11 FINISH: 18-10-12 4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

240 - ***RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURE FOR 24HOURS AS PER DWG DEO***

265 - Photocopy bluefile and create labels as per PPP D407-667-205 CHG009

270 - Identify and in kanban rack

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D407-667-205TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2873-045	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2894-1	2.75 Support	1 Ea (1 ea)	230-Crosstubes	
D3190-1	Chaffing Shield	2 Ea (2 ea)	230-Crosstubes	
D3595-063-430	Rubber Cushion 0.63" Wide X 4.30" Long	2 Ea (2 ea)	230-Crosstubes	
MS20601-AD4W8	Rivet	14 Ea (14 ea)	230-Crosstubes	
MS21920-22	Clamp	4 Ea (4 ea)	230-Crosstubes	
MS21920-25	Clamp	2 Ea (2 ea)	230-Crosstubes	
NAS1149D0563J	Washer	18 Ea (18 ea)	230-Crosstubes	5093373
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging	5054109
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging	5058983
AN5-34A	Bolt	4 Ea (4 ea)	250-Packaging	5019410
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging	5083541X1 5093592

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D407-667-205TRN	1	8	0
230-Crosstubes	D2873-043 5089003	2	109	0
	D2873-045 5050682	2	23	0
	D2894-1 5054586	1	10	0
	D3190-1 158928	2	69	0
	D3595-063-430 5074227	2	40	0
	MS20601-AD4W8 5066928	14	228	0
	MS21920-22 5073265	4	83	0
	MS21920-25 5107731	2	116	0
250-Packaging	NAS1149D0563J	18	2,086	0
	AN5-10A	10	303	0
	AN5-32A	4	365	0
	AN5-34A	4	89	0
	MS21042L5	4	1,100	0

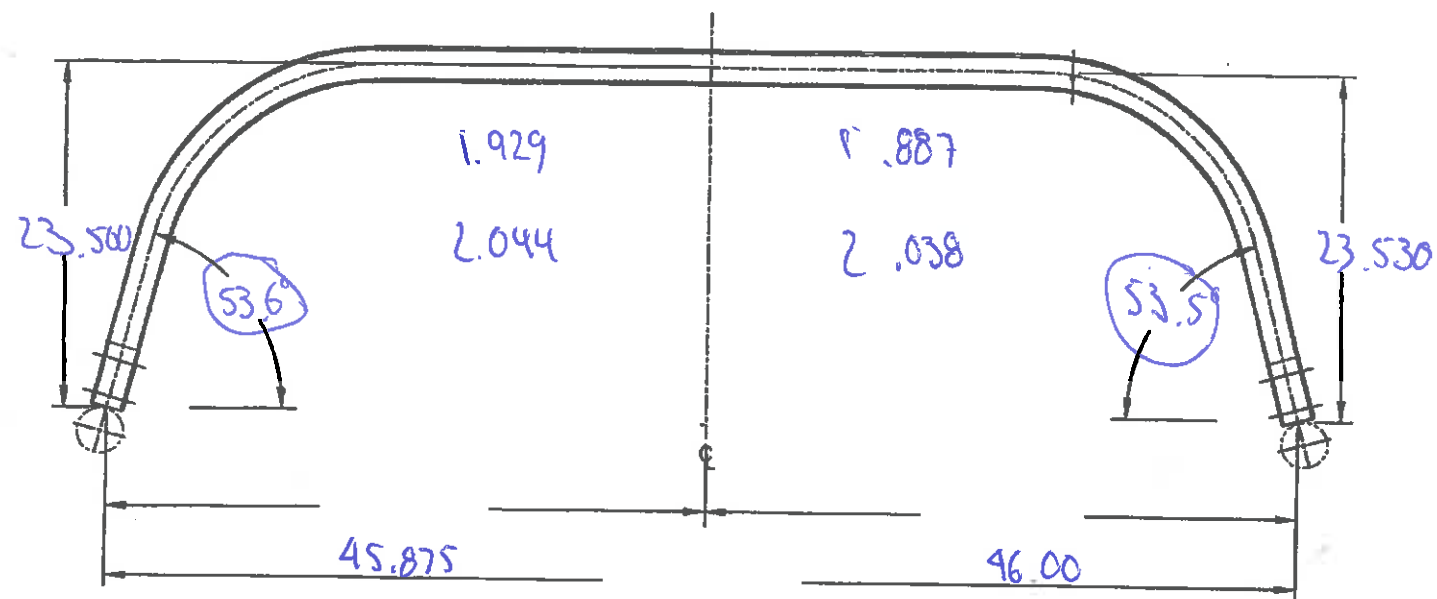
Part Specifications

Specifications could not be found.

Plex 8/14/18 11:24 AM dart.white.jesse

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Aft (407)		Part Number:	D407-667-205
Inspection Dwg: D407-667-245	Rev: G	Page 1 of 1	

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	45.79	46.05
Angle	54	56
Total Span	91.58	92.100
Bending Passes	6	--
Crushing	--	6%



	Side A	Side B
Bending Passes	27	26
Crushing	2.9%	3.8%
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.22	Dwg Rev updated	KJ	
C	11.08.22	Dimensions updated	KJ	
D	11.09.30	Dimensions updated	KJ	
E	12.04.16	Added bending, crushing dimensions	KJ	
F	15.05.14	Dwg Rev updated	KJ	

Item	QTY -245	PART NUMBER	DESCRIPTION
	X	D407-887-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
1	1	D6011-115	CROSSTUBE
2	2	D2873-043	NUT PLATE
3	2	D2873-045	NUT PLATE
4	1	D2894-1	SUPPORT
5	2	D3180-1	CHAFING SHIELD
6	2	D3585-083-430	RUBBER CUSHION
7	14	MS20801AD4W8	RIVET (OR NAS9302B-4-8)
8	4	MS21920-22	CLAMP
9	2	MS21920-25	CLAMP (OR MS21920-24)
10	AR	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD
11	AR	PROSEAL 880	SEALANT

GENERAL NOTES:

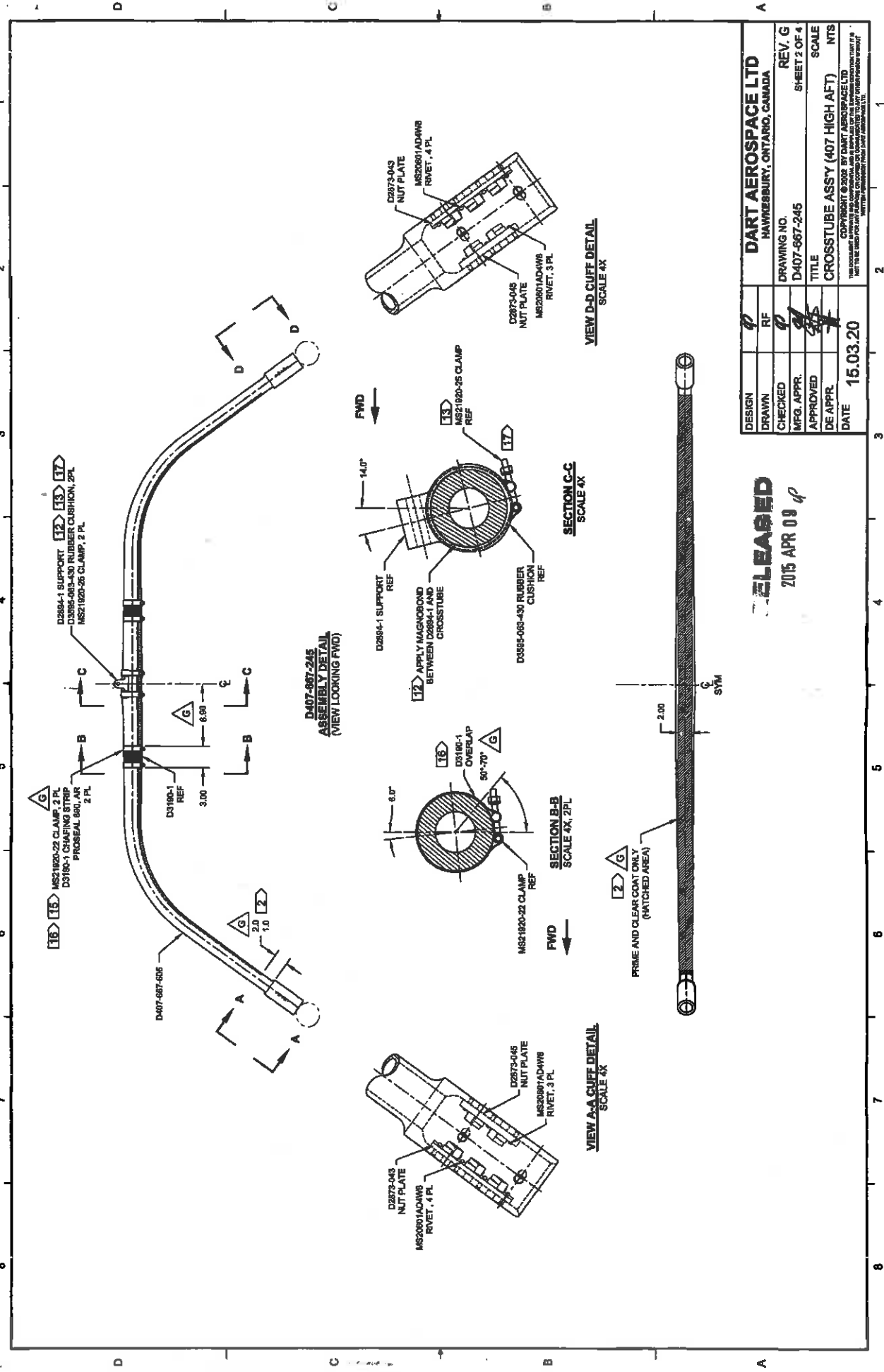
- MATERIAL: MANUFACTURED FROM D6011-115
- FINISH: FINISHED LENGTH = 112.8150.020
PRIME INSIDE AND OUTSIDE PER DART Q81 005 4.1
PAINT CROSSTUBE PER DART Q81 008 4.2
FOR HATCHED AREAS (ZN A9-2), MASK AS REQUIRED
TO APPLY PRIME AND APPLY CLEAR COAT ONLY
- TOLERANCES ARE PER DART Q81 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: .005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D407-887-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 27.7 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART: BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER Q81 038.
- INSTALL D2894-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER Q81 016. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS WITH D3585-083-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- APPLY A THIN COAT OF PROSEAL 880 ON INSIDE CONCAVE SURFACE OF D3180-1 CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEAL 880 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- INSTALL D3180-1 CHAFING SHIELDS SO THAT OVERLAP IS 50 TO 70 DEGREES FROM BOTTOM OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- TORQUE CLAMPS 90 TO 100 IN-LB. TORQUE CLAMPS ON D3180-1 CHAFING SHIELD 40 TO 50 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TIGHTENING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

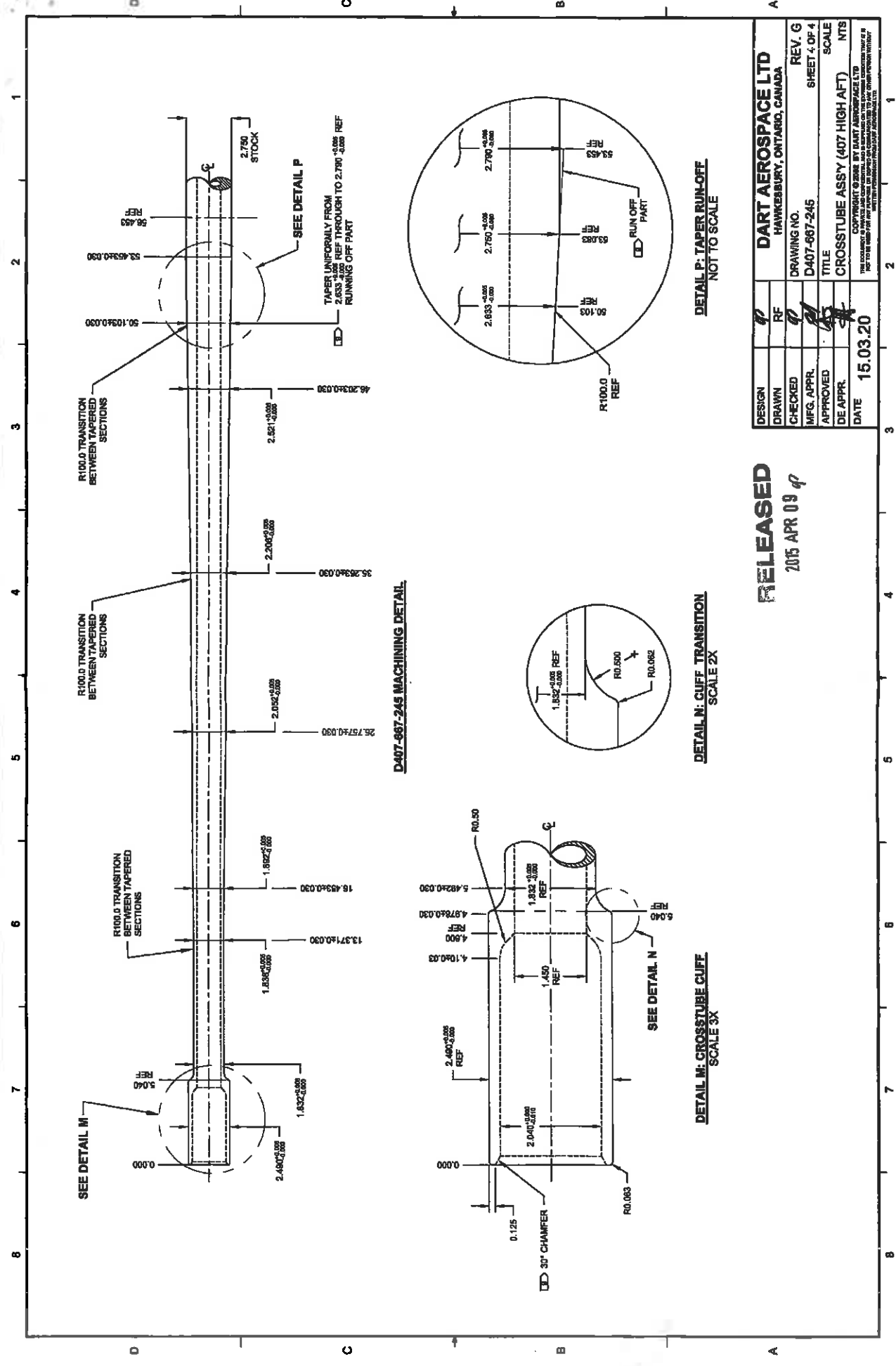
G	INCORP. DEV'S D407-887-245-F14F2 (ZN D6-1, A9-1, D6-2, B9-2, C9-2); 8.90 WAS 8.53 (ZN D6-2); TORQUE REDUCED FOR CHAFING SHIELD (ZN A9-1); FINISH REVISED TO ALLOW MANUFAC. FLEXIBILITY (ZN C8-1)	RF	15.03.20
F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 8 (ZN A9-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.08
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.373 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR908-21 AND ECN#123	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES. ROTATE ORIENTATION OF CLAMPS SECTION F-F. REMOVE -861 ABRASION STRIP, ADD MAGNIBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BR717AA SKIDTUBES	PH	05.07.28
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	15.03.20		

RELEASED

2015 APR 09
644 15-537

DESIGN	RF	DESCRIPTION	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO.	D407-887-245
MFG. APPR.	RF	TITLE	CROSSTUBE ASSY (407 HIGH AFT)
APPROVED	RF	SCALE	NTS
DE APPR.	RF	NTS	
DATE	15.03.20		





RELEASED
2015 APR 09

DESIGN	40	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	
INFO. APPR.	40	DRAWING NO. D407-667-245
APPROVED	40	REV. G SHEET 4 OF 4
DE APPR.	40	TITLE CROSS-TUBE ASSY (407 HIGH AFT)
DATE	15.03.20	SCALE NTS

CONVENTION OF DIMS BY DART AEROSPACE LTD
THIS DOCUMENT IS APPROVED AND AUTHORIZED FOR RELEASE ON THE FOLLOWING CONDITIONS: THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY INTENDED.

Entered:

Date:

NCR No. 19-7307

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only

Job: 181962		DISPOSITION		DEPARTMENT/PROCESS		Engineering	
Part No. 2407667-205		Rework ☐ Scrap ☐ Use-as-is ☒		Cross tube ☒ Small Fab ☐ Finishing ☐		Water Jet ☐ Supplier ☐ Quality ☐	
Date: 18/8/20		Sequence #:		QTY Affected:		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By: 12 9/10/20			
After bending, angles are under tolerance		Acceptable.		Lead hand / Supervisor: 11/10/20			
Root Cause		Pressure/Forced Bending ☒ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		QC / QA Coordinator: DAS 55 9-89		QC / QA Coordinator: 19-7-11			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200

PURCHASE ORDER PO040976

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO040976
PO Date: 9/11/18
Due Date: 9/13/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180615	D4464-041	Fuel Tank Assembly : Various STC's ISSUE P/O LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
2	178952	D407-667-205	Aft Crosstube - High 407 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 0380	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
179372		X	SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
179373		X	SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
179374		X	SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
181961		X	SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
181962		X	SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
Sub Total:							6	0	6		\$697.06



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PURCHASE ORDER PO040976

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	174618	D350-748-101	FWD Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 Issue P/O: Stress relief at 375degree for 5hrs Magnetic Particle Inspect per ASTM E1444 Cad Plate per AMS-QQ-P- 416B, Class 1, Type 2 Embrittle relief at 375 defree for 8 hrs, Chromate Treat C of C req'd	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174634	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174639	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174642	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174643	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
Sub Total:							5	0	5		\$580.88

4	174673	D350-748-201	Aft Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO METCOR: AFTER BENDING: STRESS RELIEF AT 650° F ± 25° F FOR A MINIMUM OF 2 HRS AIR COOL TO AMBIENT TEMPERATURE note: crosstube made from 4130 seamless steel tube DETAIL C OF C REQUIRED	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174674	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174676	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	181140	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	181141	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
Sub Total:							5	0	5		\$580.88



Dart Aerospace Ltd.

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Hawkesbury, ON

K6A 1K7

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PURCHASE ORDER

PO040976

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$1,975.00
Order Notes											
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.											

Plex 9/13/18 7:53 AM dart.lavoie.chantal



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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Fax 613 632-5246

SUBCONTRACT SHIPPER

SUBCONTRACT SHIP TO

Ship To: Skyservice
6120 Midfield Road
Mississauga, ON L5P 1B1 Canada
Phone: 905-678-5636 Fax: 905-678-5841

SHIPPER

Shipper No: 614
Shipper Date: 9/13/18
Carrier: *
Ship Via:
Vehicle Reg:
Note:
Freight Terms:

Part Information

Part No: D350-748-101
Cust Part No: D350-748-101
Reference No:
Part Information Note: DWG REV H IPP Rev:A New Issue 06-07-05 JLM
IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
VERIFY BY:DD IPP Rev:C Rev B 07-11-15 DD IPP
Rev D Combined manufacturing 08.04.02 EC verified
by: DD IPP Rev:E 08-06-24 revD as per dwg DD
verified by:EC IPP Rev:F 10.08.04 added QSI010 4.3
DD ver:EC IPP REV:G ADD UNDER BEND
COMMENT 12-05-28 JLM IPP REV:H 12.11.05 as
per dwg D350-748-141G DD ver:JLM IPP REV:I
15.03.19 as per dwg D350-748-141revH dd ver:jlm
Drawing No:
Program:
Program Customer:
Addl Docs:
Commercial: Product Line: Crosstube - High
Primary OEM Application: Airbus
Manufacturer: DART
Advertised on web?: No
Shipping Dims & Weights: Metric: L2.29m x W0.86m x
H0.18m,Actual Weight of 26.31 kg
Shipping Dims & Weights: Imperial: L90" x W34" x
H7",Actual Weight of 58 lbs

Name: FWD Crosstube AS350 / AS355
Product Family: Landing Gear
Piece Weight: 0 lbs
Alloy Type:
Alloy - Temper: -
Description: TC STC SH06-27 Issue 2, FAA STC SR02359NY
11/03/04, EASA STC EASA.10016903 Revision 2
10/09/03, BRAZIL 2009S04-04 09/04/06
Quantity:

OPERATION

Operation: Outsource - 174

Description: ISSUE P/O TO SKYSERVICE: _____

Note:

DETAIL

Part	Operation	PO	Job	Container	Heat Code	Net Weight (lbs)	Gross Weight (lbs)	Quantity
D350-748-101 09/20/2017 LMC Can Only Be Sold To AVIC. Discontinued And Replaced By D350-748-103. Oversized Item, Please Refer To Shipping Instructions.	Outsource ISSUE P/O TO SKYSERVICE: _____	PO040976	174634	S093239		0	0	1
			174639	S093544		0	0	1
			174642	S093602		0	0	1
			174618	S093751		0	0	1
			174643	S093762		0	0	1
D350-748-201 09/20/2017 LMC Can Only Be Sold To Avic. Discontinued And Replaced By D350-748-203.	Outsource ISSUE P/O TO SKYSERVICE: _____	PO040976	174673	S094573		0	0	1

9/13/2018

[Dart Hawkesbury] Subcontract Shipper - Lavoie, Chantal

Oversized Item, Please Refer To Shipping Instructions.			174674	S094587		0	0	1
			174676	S094598		0	0	1
			181140	S095319		0	0	1
			181141	S095366		0	0	1
D407-667-205	Outsource	PO040976	181961	S103098		0	0	1
09/20/2017JR Oversized Item, Please Refer To Shipping Instructions.	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038O							
			178952	S103104		0	0	1
			179373	S103183		0	0	1
			179372	S103185		0	0	1
			181962	S103187		0	0	1
			179374	S103902		0	0	1
D4464-041	Outsource	PO040976	180615	S100152		0	0	1
09/20/2017JR D4464-041 Aux Fuel Tank Reservoir (Ref. D350-794-141) Is About 0.25" Longer Than The D4055-041 Aux Fuel Tank Reservoir (Ref. D350-794-041); Please Contact Technical Support For More Details (Ref.: Case 9383).	ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2							
Total			17			0	0	17

Driver Signature

Customer Copy

Plex 9/13/18 8:03 AM dart.lavoie.chantal



Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37372	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO040976
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED

Sequence: 1

Work Required:

CARRY OUT NDT ON:

1 FUEL TANK , P/N# D4464-041 , J/S# 180615 ✓

6 AFT CROSSTUBES , P/N# D407-667-205 , J/S# 181961 , 181962 , 179372 , 179373 , 179374 , 178952 ✓

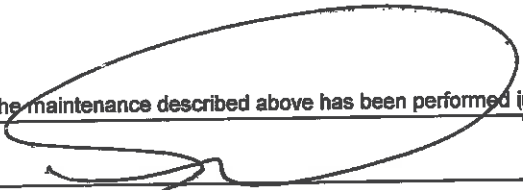
5 FWD CROSSTUBES , P/N# D350-748-101 , J/S# 174618 , 174639 , 174642 , 174643 , 174634 ✓

5 AFT CROSSTUBES , P/N D350-748-201 , J/S# 174673 , 174674 , 174676 , 181140 , 181141 ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16							
3 LEAKS FOUND IN FUEL TANK							
REMAINING ITEMS: NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							

Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 

Name: **RAFIK MELIKIAN**

ACA/SCA Stamp

DOT-APP 20 53-89

Date:

SEP 11 2018